

Work Order ID 78309-2

January-05-12 8:31:42 AM

\*78309\*

Page 1

Item ID: D2282-043

Revision ID:

Item Name: Saddle Assembly

Start Date: 05/01/2012 Start Qty: 50.00

Required Date: 23/03/2012 Req'd Qty: 50.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: M.L.J

QC:

Date: 12/01/05 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2282	Rev E								
100		0.00							
*100*	Large Fab								
Large Fab	Memo	0.00							
Large Fab	I-Weld as per D2282-043 Saddle Assembly A/RER316L SS Filling Rod <u>M115778</u> Dwg Rev: _____								
110		0.00							
*110*	Small Fab								
Small Fab	Memo	0.00							
Small Fab	I- Grind weld with rough pad and brown pad, take all welding marks out and deburr holes***DO NOT TAKE RED AND BLUE PAD TO BUFF PART***								
120		0.00							
*120*	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

12-03-28 50x

Ac 12-03-07 (54x)

54x

12-03-07



# Work Order ID 78309

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Item ID: D2282-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle Assembly

Start Date: 05/01/2012 Start Qty: 50.00

**\*50\***

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 50.00

**\*50\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

0.00

**\*130\***

Small Fab

Memo

0.00

Small Fab

1 -Tumble

B123-20

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

Ss 12603/20

29

160

Identify as per dwg & Stock Location: GA

0.00

**\*160\***

Packaging

Memo

0.00

Packaging

Ss 12603/20

29



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January-05-12 8:31:42 AM

Item ID: D2282-043

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Saddle Assembly

Start Date: 05/01/2012 Start Qty: 50.00

\*50\*

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 50.00

\*50\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

170

QC21- Final Inspection - Work Order Release

0.00

\*170\*

QC

Memo

0.00

Quality Control

ML 12/03/12

ML 12/03/12





# Picklist Print

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Work Order ID: 78309

\*78309\*

Parent Item: D2282-043

\*D2282-043\*

Parent Item Name: Saddle Assembly

Start Date: 05/01/2012

Required Date: 23/03/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2281		Manufactured	No			100	Each	73.0000	1				
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\*D2281\*

Jack Saddle

Location

Loc Qty

Loc Code

WA020

73

67539

67

74885

6

D2282-7		Manufactured	No			100	Each	34.0000	2				
---------	--	--------------	----	--	--	-----	------	---------	---	--	--	--	--

\*D2282-7\*

Tube

Location

Loc Qty

Loc Code

WA021

34

67540

34

\*\*

\*\*

12-03-20

B78310 → 91x+4  
B80015 → 9x+8

12-02-27

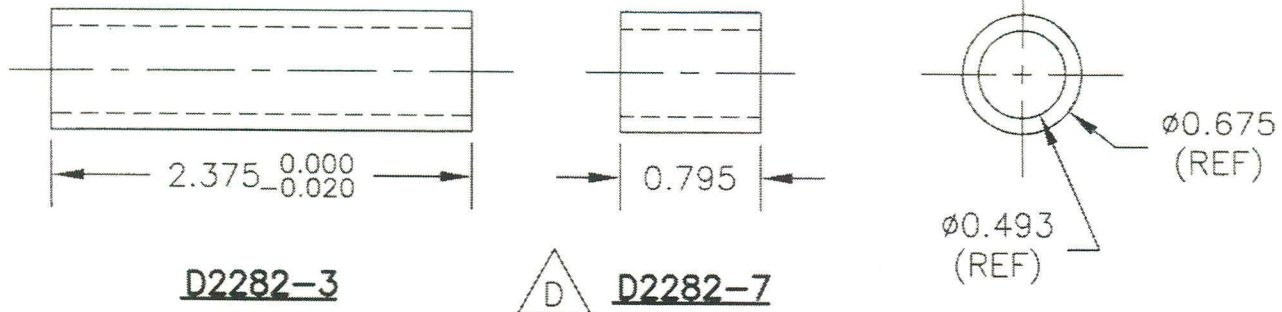




**DART**

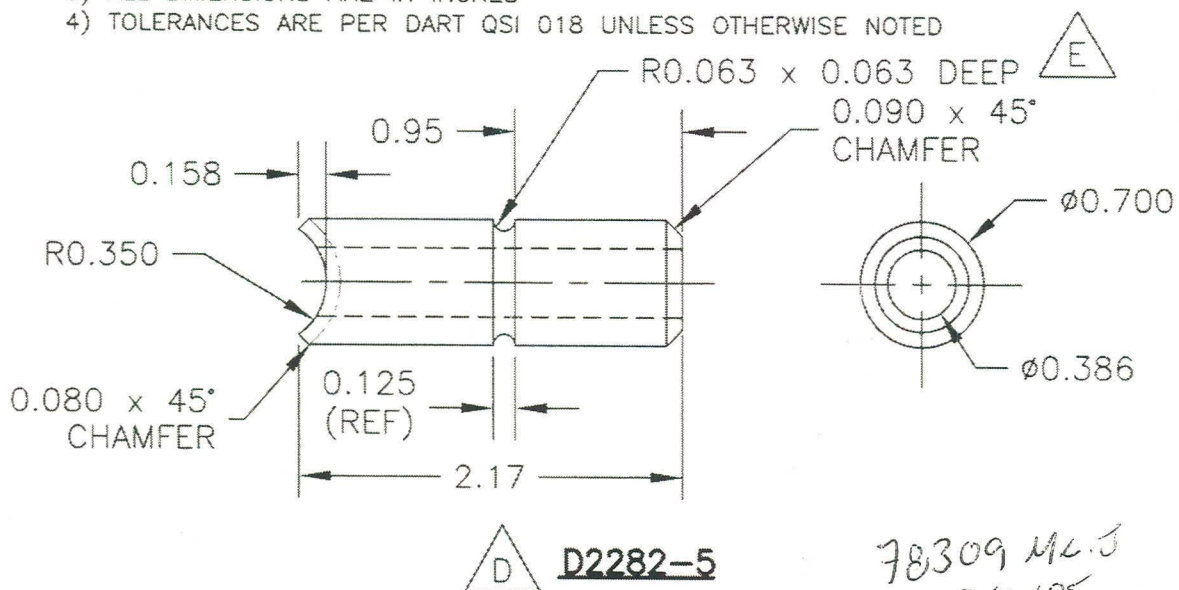
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED  
*[Signature]*  
05/09/16



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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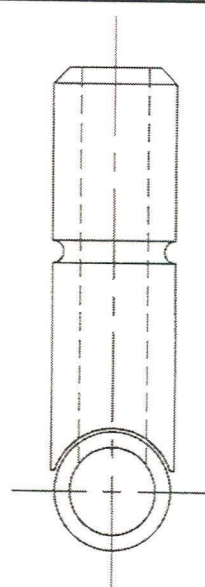
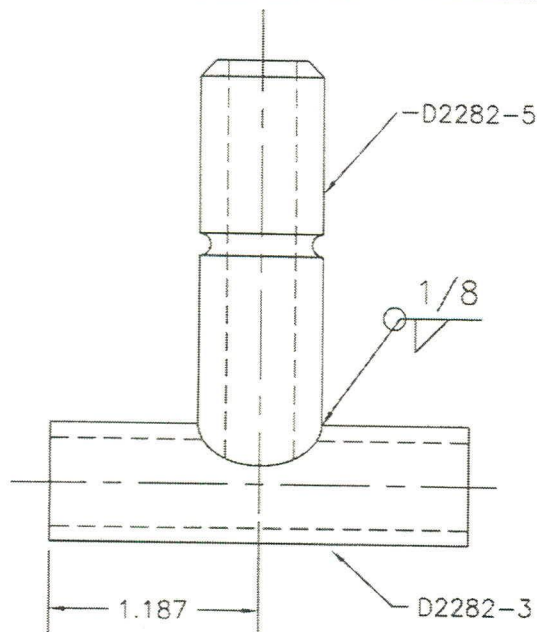
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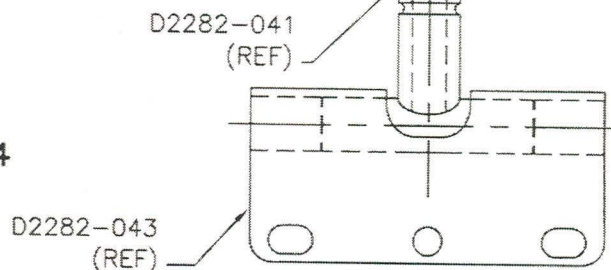
78309

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1

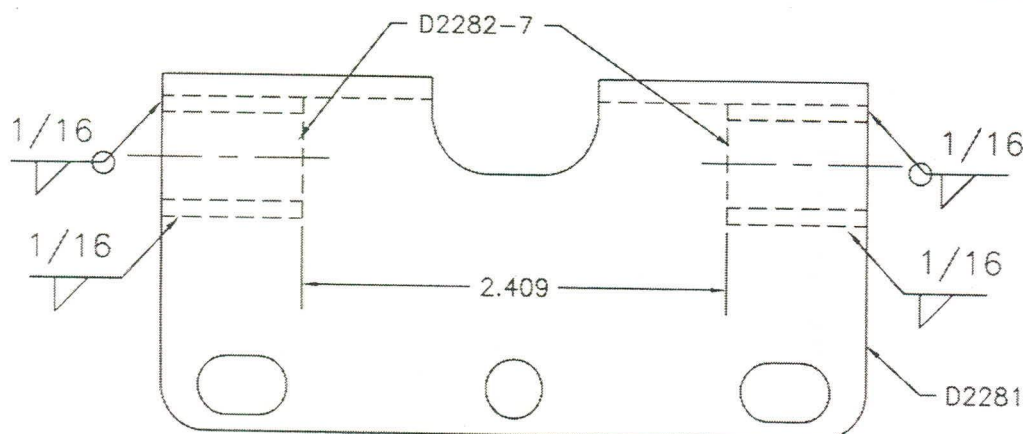


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*[Signature]*  
05/09/16

**D2282-041 'T' ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004



**GENERAL ASSEMBLY**  
SCALE 1:2



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

*78308*

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